

Work Order ID 154597

Thursday, December 15, 2016 1:34:00 PM

154597

Page 2

Item ID: D3823-2KIV Accept ***N900040100*** Setup Start ***NS1***
Revision ID: - Stop ***NS2***
Item Name: Overhead Rear, RH-Ivory
Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA031 using tool DT9113 Dwg Rev: <u>C</u> Folio Rev: <u>B</u> Visually inspect for proper formation and texture	0.00 0.05				<u>1</u>			DAS 07 9-89 16/12/20
140 *140* HandThermo Hand Finishing Thermoforming	Memo 1-Trim to finished dimensions as per Dwg	0.00 0.15				<u>1</u>			DAS 07 9-89 16/12/21
150 *150* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Complete FAI document	0.00 0.00				<u>1</u>			DAS 07 9-89 16/12/22

Picklist Print

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Work Order ID: 154597

154597

Parent Item: D3823-2KIV

D3823-2KIV

Parent Item Name: Overhead Rear, RH-Ivory

Start Date: 12/12/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased		No			sf	1,738.890		11.15558			DAS 07 9-89

MKYD6185S 080-P3-62015

Kydex Ivory (52"x96"-.080)

Location	Loc Qty	Loc Code
SHED	728	
m129761	347	
m130671	381	
therm	1010.89	
121755	13.44	
<u>124462</u>	997.45	

16/12/20

11.16-58 H.

DART AEROSPACE LTD		Work Order: 154597
Description: Rear Overhead, RH		Part Number: D3823-2KIV/KGY
Inspection Dwg: D3823	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DAS 07 9-89	Date: 16/12/20
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TRIMMING SECTION

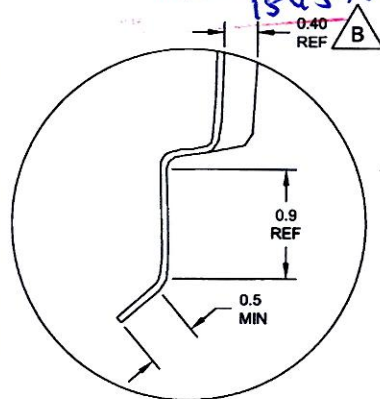
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	0.60"	✓			
0.44	Min	0.50"	✓			
1.75	Min	1.91"	✓			
0.045	Min	0.053"	✓			
0.055	Min	0.065"	✓			

Measured by: DAS 07 9-89	Date: 16/12/22
Audited by: 9 9-89	Date: 16-12-22
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	

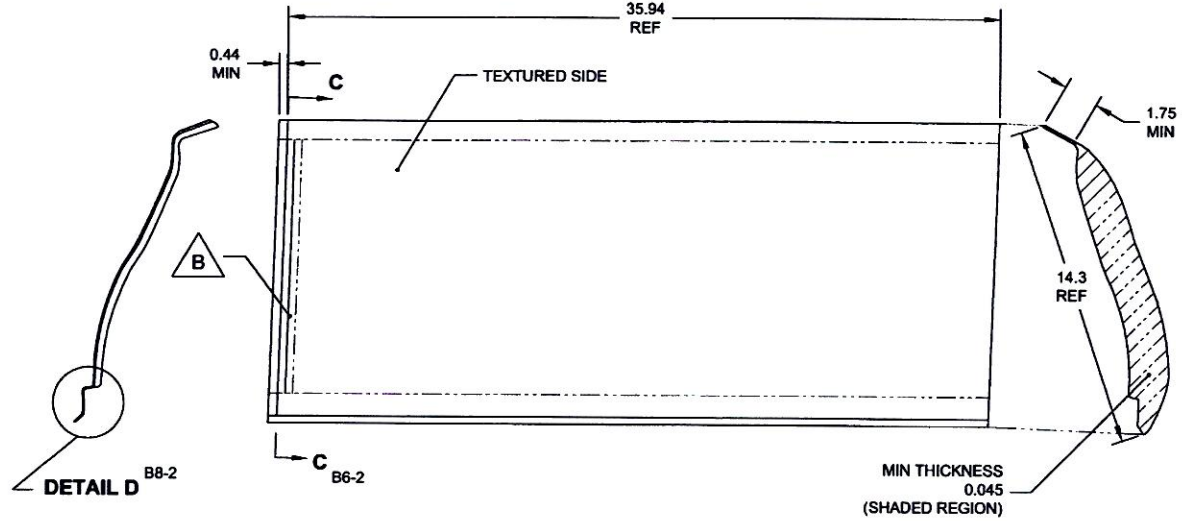
8 7 6 5 4 3 2 1

350 COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
154597 MLS
16-12-15



DETAIL D
B5-2
SCALE 5X

SECTION C-C
B4-2



D3823-2 REAR OVERHEAD, RH

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9113 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3823-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	REV. C	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. C D3823 SHEET 2 OF 3 TITLE SCALE REAR OVERHEAD NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.05.05	

RELEASED
21/05/12

8 7 6 5 4 3 2 1